

Order ID 99890-2

ay, April 12, 2013 3:24:41 PM

99890

ASAP

Page 1

Item ID: D4125-1

Revision ID:

Item Name: Sump

Start Date: 4/12/2013

Required Date: 4/19/2013

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

6

6

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D4125

C

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

100

100

Bandsaw

Jaspa Bandsaw

Memo

1-Cut Blank at 13.375"

0.00

0.00

0.00

0.00

105

105

HAAS I

HAAS CNC vertical machine #1

Memo

Machined as per folio FB078

Rev: C

Dwg: C

Deburr

FK 13/04/29

Work Order ID 99890

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Page 2

Item ID: D4125-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Sump

Start Date: 4/12/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

FJE 12/04/29

10

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

10

SL1343

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

9 1613.57

Hand Finishing

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Item ID: D4125-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Sump

Start Date: 4/12/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3 Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

9

φ

DAS
19
9-33
13.05.09

150

Identify as per dwg & Stock Location: WAC003

0.00

150

Packaging

Memo

0.00

Packaging

9

φ

13.05.8

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/5/15

MF
13-5-13

Picklist Print

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Page 1

Work Order ID: 99890

Parent Item: D4125-1

Parent Item Name: Sump

Start Date: 4/12/2013

Required Date: 4/19/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.21 new issue DD verf:EC
IPP Rev:B 11/12/05 as per dwg. rev.B JFS verf:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000 6061-T6 BAR 2.00' X 8.00"		Purchased	No			100	f	4.7370	1.115	7.0421053	80	13/04/25	

Location

Loc Qty

Loc Code

MAT005

4.737

123089

0.085

124443

3.252

125034

1.4

→ 125386

11.2

DART AEROSPACE LTD		Work Order:	99890
Description: Fwd Sediment Bowl		Part Number:	D4125-1
Inspection Dwg: D4125 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20	+/-0.030	.200	✓		FK-04	Vern.
6.23	+/-0.030	6.236	✓		"	"
3.56	+/-0.030	3.563	✓		"	"
2.61	+/-0.030	2.611	✓		"	"
0.25	+/-0.030	.25	✓		"	"
0.25	+/-0.030	.25	✓		"	"
11.87	+/-0.030	11.866	✓		FK-08	Vern.
0.31	+/-0.030	.32	✓		FK-04	Vern.
6.01	+/-0.030	6.01	✓		FK-08	Vern.
11.98	+/-0.030	11.98	✓		"	"
0.06	+/-0.030	.06	✓		FK-04	Vern.
1.37	+/-0.030	1.368	✓		"	"
2.99	+/-0.030	2.99	✓		"	"
0.30	+/-0.030	.30	✓		"	"
Ø0.348	+0.006/-0.001	.348	✓		"	"

Measured by: Fk	Audited by: JL	Preliminary Approval:
Date: 13/04/29	Date: 13.4.3	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	